

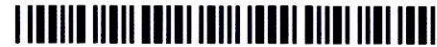


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2666-2

Job Sheet 208751



Part No: D2666-2

Job Qty: 12 pcs

Part Name: Saddle, RH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/31/20

Job Tracking No:

Due Date: 4/30/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	4/29/20		1.00	12.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/21
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	4/29/20		0.00	1.85	Conventional Mill - 1 - B4B		SBL 20/04/21
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	4/29/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S271841



Part: D2666-2

Job No: 208751

Serial No/Batch: S271841

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/20/20

						QC 2 - 57	SBL 20/04/21
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
130 QC 8	12 pcs	4/29/20	0.00	0.00		QC 8 - 12	
						QC 8 - 14	20/04/21
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	4/29/20	0.00	1.41		Handfinish - 1 - 1 - B4B	20-04-21
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	

				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	4/30/20	0.00 0.41	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	12 pcs	4/30/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170	Packaging 3-1 - Stock - B4B	12 pcs	4/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

DAS 34 9-89

DAS 82 9-89

APR 22 2020

DAS 28 9-89

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	12 pcs	4/30/20	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 53
Part Op 100 - HAAS CNC Vertical Machine - Program batch number. 1-Inspect part number and batch number are programmed Descriptions: correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis	S269795 x (8)	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	12	32	0	
Part Specifications					
Specifications could not be found.					

Plex 4/1/20 8:16 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 208751
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.124	0.124	0.124	0.124	0.124
B	0.100	0.140		0.129	0.129	0.130	0.130	0.130
C	2.470	2.510		2.495	2.495	2.495	2.495	2.495
D	0.100	0.180		0.130	0.133	0.133	0.133	0.133
E	0.210	0.230		0.224	0.224	0.224	0.224	0.224
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325
G	0.240	0.260		0.256	0.255	0.256	0.255	0.255
H	0.615	0.685		0.660	0.660	0.660	0.660	0.660
I	1.125	1.145		1.135	1.135	1.135	1.135	1.135
J	0.990	1.010		1.004	1.005	1.005	1.005	1.005
K	0.235	0.240		0.239	0.239	0.239	0.239	0.239
L	0.510	0.515		0.511	0.511	0.511	0.511	0.511
M	0.100	0.120		0.105	0.105	0.105	0.105	0.105
N	1.565	1.585		1.575	1.575	1.575	1.575	1.575
O	5.990	6.010		6.000	6.001	6.001	6.001	6.001
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.500	0.500	0.500	0.500	0.500
S	0.312	0.318		0.313	0.313	0.313	0.313	0.313
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		0.316	0.316	0.316	0.316	0.316
W	0.540	0.560		0.550	0.550	0.549	0.550	0.549
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: DDP/SBC	Date: 20/04/21
Audited by: [Signature]	Date: 20/04/21
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 208751
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666	Rev: D	Page: 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
A	0.100	0.140		.124	.124	.124		
B	0.100	0.140		.130	.130	.129		
C	2.470	2.510		2.495	2.495	2.495		
D	0.100	0.180		.133	.133	.133		
E	0.210	0.230		.224	.224	.224		
F	1.313	1.343		1.324	1.325	1.325		
G	0.240	0.260		.254	.254	.255		
H	0.615	0.685		.660	.660	.660		
I	1.125	1.145		1.135	1.135	1.135		
J	0.990	1.010		1.004	1.005	1.005		
K	0.235	0.240		.239	.239	.239		
L	0.510	0.515		.511	.511	.511		
M	0.100	0.120		.105	.107	.107		
N	1.565	1.585		1.575	1.575	1.575		
O	5.990	6.010		6.002	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.500		
S	0.312	0.318		.313	.313	.313		
T	2.495	2.505		2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362		
V	0.315	0.322		.316	.316	.316		
W	0.540	0.560		.550	.549	.550		
X	1.674	1.684		1.679	1.679	1.679		
Y	0.256	0.262		.258	.258	.258		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20/04/21
Audited by: [Signature]	Date: 20/04/21
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 208751
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140						
B	0.100	0.140						
C	2.470	2.510						
D	0.100	0.180						
E	0.210	0.230						
F	1.313	1.343						
G	0.240	0.260						
H	0.615	0.685						
I	1.125	1.145						
J	0.990	1.010						
K	0.235	0.240						
L	0.510	0.515						
M	0.100	0.120						
N	1.565	1.585						
O	5.990	6.010						
P	1.245	1.255						
Q	2.495	2.505						
R	0.490	0.510						
S	0.312	0.318						
T	2.495	2.505						
U	1.357	1.367						
V	0.315	0.322						
W	0.540	0.560						
X	1.674	1.684						
Y	0.256	0.262						
Z	0.178	0.198						
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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G	12.03.08	Dimension S and Y revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					